Work Orde June-12-13 9:1.		102758	D :	2230-3	*10	)2758*						Page 1
Item ID: Revision ID: Item Name:	D2230-3	The state of	В	102758	Accept	*N90	<b>0040</b>	100	)* s	etup Start Stop	I VI	S1* S2*
Start Date: Required Date: Reference:	6/11/13	_	ty: 100.00 Qty: 100.00	*100 *100		Cust Iter				St.	4 -	
Approvals:	Process	s Plan: MC	,3	Date: 13-06-1	3 Tooling:		Date:		R	tun Star Stop	1/1	R1*
	QC: _			Date:	SPC (Y/N):		Date:				*N	R2*
Sequence ID/ Work Center I	D	Operation Descript			Set Up/ Run Hou	Tool II	O Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		Revision Nbr										
D2230		Rev G									·	
*110 *110* Outsource5 Outsource process	- Machining	HAAS CN	process - Mach IC VERTICAL Memo Issue P/O to I Machine as p C of C is requ	MACHINING #1  Metec: 26\56  per dwg	0.00				cx	13/00	6113	<u>/00</u>
120		Receive &	Inspect for Da	mage & Mat'l Certs	0.00					1		
*120* Packaging Packaging			<b>Memo</b> Ensure C of 0	C is attach	0.00				(	/43	78	(JUV)
130 *4.20*		QC6- Insp	nect dimensions	to drawing	0.00	27			100,			,
*130* QC Quality Control			Memo		0.00 13	7.8			an	)		

DQA:			Date:					4	. •					•	DA PT
			_			WORK ORDER NON-	-CC	ONFO	RMANCE / U						AEROSPACE
QA Closed:			Date:		1						Wo	ork Order up	date only		
Work Orde	er:					DISPOSITION		•		AGAINST	DE	PARTMENT	/PROCESS		
						Rework	1		Skid-tube	Crosstube		]	Water Jet		Engineering
Part N	No.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	$\exists$	Quality
	_	<del> </del>				Use-as-is			noforming	Finishing		l	re/Packaging		Other
NCR N	No					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update		Initial	Act	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	n l	QC Inspector
Design															,
Doc/Data															:
Equip/Tooling															
Handling/Pre															
Material															·
Operator	Ш														
Offset/Setup	Ц														
Process	Ш			18.											:
Supplier															
Training	Ш														
Transport														İ	
Unapproved															
<u> </u>							FA	ULT CA	regory						
Landi	ng Ge	ar				General	_	•		,					
	$\vdash$	ending			<u> </u>	Bend		4 '	Program			Outside Dim			Pressure/Forced
	$\Box$ <sup>C</sup>	entre No	ot Concer	ntric	<u> </u>	BOM/Route		Grain				Over/Under	tolerance		Set-up
	_	racks			<u> </u>	Broken/Damage/Defect		Hardwa	ire	į		Part Incorred	ct		Temperature/Cure
		rimp/Kin	ık/Ripple	/Wave	_	Burrs	L_	Inspect	ion Incomplete/Ui	nqualified		Part Lost/Mi	ssing		Weld
		uffs			<u> </u>	Contamination		1	ions Incomplete/l	Jnclear		Part Moved			Wrong Stock Pulled
	-	rushing			<u> </u>	Countersink		1 7	ned/off center			Positioned V	Vrong	_	•
	$\vdash$	eat Trea				Cut Too Short	—	Mislabe				Power Loss/	Surge		Other
			n Strip in	Tube		Drawing	-	Misread							
	$oldsymbol{oldsymbol{ o}}$	larks/Ch				Drill Holes	<u></u>	Off-set					·		
	${f -}$		equence			Finish	<u></u>	Out of	Calibration				<del> </del>		
	<u> </u>   \	/ave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence						

Work Orde June-12-13 9:13	er ID 102 3:30 AM	2758		*102	758*			Page 2
Revision ID:	D2230-3			Accept	*N900040	1100*	Setup Start Stop	*NS1*
	Lug 6/11/13 6/11/13	Start Qty: 100.00 Req'd Qty: 100.00	*100 *100		Cust Item ID: Customer:			*NS2*
Approvals:	Process Pla	n:	Date:	Tooling:	Date:		Run Start	*NR1*
	QC:		Date:	SPC (Y/N):	Date:		Stop	*NR2*
Sequence ID/ Work Center II 140 *140*	)	Operation Description Chemical Conversion Coan	t per QS1005 4.1	Set Up/ Run Hours 0.00	Tool ID Tool #	Plan Acc Code Qty		Reject Insp. Number Stamp
HandFinish Hand Finishing		Мето		0.00				
150 *150*		QC Inspect Part Finish		0.00		/// >	x X M.L	13/07/1,
QC Quality Control		Memo		0.00		1007		
160		White Gloss(Ref:4.3.5.1) p	per QSI005 4.3-Alum	0.00		,		/ 1
*160* Powder Coating	. 2	<b>Memo</b> START TIME OVEN TEMP FINISH TIME	ERATURE: 50	30.00		/U <u>u</u> y	pmf	13/07/1,

DQA:		_ Date:			WORK ORDER NON	cc	SNIFOI	DRAANCE / LIDDA'	TC			
QA Closed:		Date:			WORK ORDER NON-	٠. ر ر	JINFOI	RIVIANCE / UPDA		ork Order up	date only	AEROSPACE
Work Orde	ır.				DISPOSITION			A	GAINST DE	PARTMENT/	PROCESS	.,,
Part N	lo				Rework Scrap Use-as-is Suspected Unapproved			Machining Sn noforming Fi	osstube mall Fab minishing mposite	ł.	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Desc	ription of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance		ief Eng	Description	n	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Öperator Offset/Setup Process Supplier Training Transport Unapproved												
						FA	ULT CA	regory				
Landii	ng Gear				General		1 ,-			1		7
	Cracks Crimp/ Cuffs Crushir Heat Tr	Not Conce Kink/Ripplo	e/Wave n Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misread Off-set	ion Incomplete/Unquali ions Incomplete/Unclea gned/off center eled	<b>├</b>	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
-		s Sequence Twist in Tu		-	Fit/Function	$\vdash$	4	Calibration				

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Work Orde		2758		*102	758*				Page 3
Item ID: Revision ID:	D2230-3			Accept	*N900040	100*	s Setup	Start Stop	INCOL
Item Name: Start Date: Required Date: Reference:	Lug 6/11/13 : 6/11/13	Start Qty: 100.00 Req'd Qty: 100.00	*100 *100		Cust Item ID: Customer:			эчор	*NS2*
Approvals:	Process Pl QC:	an:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 170 *170* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID Tool #		Qty Qty	y	Reject Insp. Number Stamp <u>∬ パ</u> クロー
*180 *180* Packaging Packaging		Identify as per dwg & Stoo Memo	ck Location: <u>ST4</u> 69	0.00			100 y	<i>Y</i>	1. N. 13/07/
190 *4 0 0 *		QC21- Final Inspection -	Work Order Release	0.00		_	_ /	3/-	7/17/1

0.00

Memo

Quality Control

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DQA:		Date:			WORK ORDER NON-	cc	ANE O	DAANICE / III	DDATE			*DART
QA Closed:		Date:			WORK ORDER NON-		JINFOI	AIVIAINCE / O		Work Order	update only	AEROSPACE
Work Orde	ar·				DISPOSITION				AGAINST [	EPARTMEN	T/PROCESS	
WOIR OIG	-1.				Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	10.				Scrap			Machining	Small Fab	-  P <sub>!</sub>	od. Eng. Coor.	Quality
	·			_	Use-as-is			noforming	Finishing	_	ore/Packaging	Other
NCR N	No			·····	Suspected Unapproved			Large Fab	Composite		Supplier	
Root				Desci	ription of work order update		nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material												
Operator Offset/Setup												
Process												
Supplier	H	1										
Training												
Transport												
Unapproved												
	•					FA	ULT CA	regory				
Landi	ng Gear				General		_		_		_	
	Bending				Bend	L	Folio/F	rogram		Outside Di	mensions	Pressure/Forced
	Centre N	lot Conce	ntric		BOM/Route	L	Grain			Over/Und	er tolerance	Set-up
	Cracks				Broken/Damage/Defect	L	Hardwa	ire		Part Incor	ect	Temperature/Cure
	Crimp/Ki	ink/Ripple	e/Wave		Burrs	L	Inspect	ion Incomplete/U	nqualified	Part Lost/I	Missing	Weld
	Cuffs				Contamination	<u></u>	4	ions Incomplete/	Unclear	Part Move	_	Wrong Stock Pulled
	Crushing			<u> </u>	Countersink		-	ned/off center	1	Positioned	~ ~ ~	<b>_</b>
	Heat Tre			_	Cut Too Short	L	Mislabe		Ĺ	Power Los	s/Surge	Other
	<b>—</b>	on Strip in	Tube		Drawing	L	Misread					
	Marks/C			<u> </u>	Drill Holes	<u></u>	Off-set					
		Sequence			Finish	L	4	Calibration				
	I IMave/Tu	wist in Tul	he	- 1	Fit/Function	1	I Out of	Sanuanca				

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## **Picklist Print**

June-12-13 9:13:30 AM

Work Order ID:

102758

Parent Item:

**Comments:** 

D2230-3

Parent Item Name:

Lug

coatEC

IPP D00.05.18Added inspection level 8, and removed P/O for powder IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED **Start Date:** 6/11/13

**Start Qty: 100.00** 

BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur	Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P		Purchased	No				Each	0.0000		100		0/1	
LUG											14	3/1/6	-(/-)
D2423		Manufactured	No				f	529.3330		7.18947			
Lug Extrusion									1				
				Location		Loc Qty	Ī	oc Code					
				MAT006		383							
				4372	22	161.5							
				8795	i3	221.5							
				Metec		146.333					1		
				9355	1)	146.333			<b>ક</b>	/ fl	13-	07-1	2

Page 1

Required Date: 6/11/13

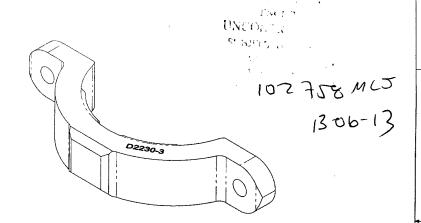
Required Qty: 100.00

DQA:			Date:	_									`	AA PT
			_			WORK ORDER NON	I-C(	ONFO	RMANCE / UPDATE				_	AEROSPACE
QA Closed:			Date:							Wo	rk Order up	date only		
Work Orde	ır.					DISPOSITION			AGAINST	T DEP	ARTMENT	/PROCESS		
l Work Orde	·· —					Rework	7		Skid-tube Crosstube			Water Jet		Engineering
Part N	lo.					Scrap	1		Machining Small Fak	$\vdash$	Pro	d. Eng. Coor.	H	Quality
						Use-as-is	1		noforming Finishing	$\vdash$		re/Packaging		Other
NCR N	lo.					Suspected Unapproved	1	i i	Large Fab Composite		·	Supplier		
					<del></del>									
Root					Desc	ription of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verificatio	n	QC Inspector
Design	_												l	
Doc/Data	_												Ì	
Equip/Tooling	_				:									
Handling/Pre	_												l	
Material	_												l	
Operator	_								,					
Offset/Setup	_											ļ		
Process	-									ľ				
Supplier	_												ļ	
Training														
Transport	$\dashv$													
Unapproved			L	<u> </u>	L			UT CAS	FECODY					
Londin						Company	FA	ULI CA	TEGORY					
Landir	_	ar ending				General Bend		]ralia/r	Program		Outside Dim	onsions		Pressure/Forced
•			ot Concer	atric .	-	BOM/Route	-	Grain	rogram	$\vdash$	Outside Diffi Over/Under		$\vdash$	Set-up
		entre int racks	or concer	ittic	$\vdash$	Broken/Damage/Defect	$\vdash$	Hardwa	aro	-	Part Incorre		$\vdash$	Temperature/Cure
	_		nk/Ripple	Mayo	$\vdash$	Burrs	$\vdash$	4	ion Incomplete/Unqualified	$\vdash$	Part Income Part Lost/Mi		$\vdash$	Weld
	_	uffs	ik) Kippie	/ wave	-	Contamination	-	<b>⊣</b> `	tions Incomplete/Unclear	$\vdash$	Part Lost/Mi	_	=	Wrong Stock Pulled
	$-$ 1 $^{\circ}$	rushing				Countersink	$\vdash$	4	gned/off center	$\vdash$	Positioned V		ш	TOTAL STOCK I WHEN
	_	leat Trea			-	Cut Too Short		Mislabe		-	Power Loss/	_		Other
	$\vdash$		n Strip in	Tube		Drawing		Misread		Ш	. 52. 2000)	0*		
		/larks/Ch				Drill Holes	$\vdash$	Off-set		-	· · · · · · · · · · · · · · · · · · ·	<del> </del>		
	$\vdash$		equence			Finish		-	Calibration	-				
	_		ist in Tub			Fit/Function		╡	Sequence	-				<u> </u>

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D2230-1

**D2230-1 MOUNTING LUG** 



**D2230-3 MOUNTING LUG** 



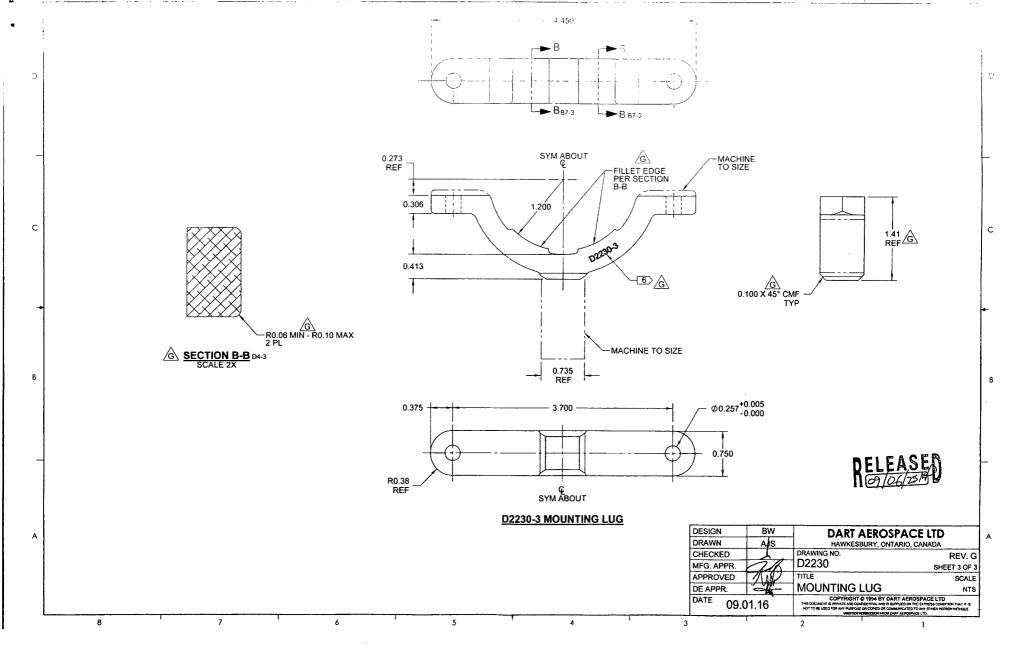
G	ADDED	ARDS, REFER	VORKS TO CURRENT DESIGN TO SECTION A-A & B-B FILLET CHAFING OF RUBBER CUSHION ON	AJS	09.01.16			
F	REDES	IGN; R1.200 W	AS 1.100	CP	99.12.13			
Ε	RE-DES	SIGN		BW	95.01.04			
D	RE-DES	SIGN		BW	95.01.04			
С	RE-DES	SIGN		BW	94.03.30			
REV.			DESCRIPTION	BY	DATE			
DESIG	N	BW	DART AEROSPA	CFL	ľD			
DRAW	V	AJS	HAWKESBURY, ONTARI		-			
CHECK	ŒD	11	DRAWING NO.		REV. G			
MFG. A	PPR.	[m].	D2230		SHEET 1 OF 3			
APPRO	VED	KM.	TITLE		SCALE			
DE APP	PR.		MOUNTING LUG N					
DATE	09.0	)1.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPOSITIVE AND IS SUFFLED ON THE EXPRESS CONDITION THAT IT IS					

<u>a</u>

С

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ±0.005.
7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

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20 Terry Fox Drive Vankleek Hill, Ontario K0B 1R0 , Canada

Received by \_\_\_\_\_

Tel: (613) 678-3957 Fax: (613) 678-3956

**Delivery Slip No.:** 

19091

Date:

Jul 02, 2013

Page:

1

Thank you for your order!

Sold to:	Ship to:
Dart Aerospace Ltd.  Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 20158	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Jul 02, 2013

	Description	Unit	Ordered :- guantity :-	Shipped quantity	Backorder quantity
D3235-1 B102818	Mounting Lug Machine as per drawing D3235 REV.A	Each	100		en en en en en en en en en en en en en e
D2230-3 B102758	Mounting Lug Machine as per drawing D2230 REV.G	Each	100	100	
3910-3 <del>C</del> B103051	resstube Lug Machine as per drawing D3910 REV.G	Each	50		50
			!		
Should there	goods must be inspected upon receipt to confirm compliance. be discrepancies please notify METEC within 30 days of delivery. e otherwise deemed accepted.				
					<u> </u>



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

## CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont.

same

K6A 1K7

QUANTITY

PART NUMBER

**PART NAME** 

P.O. NUMBER

100

D2230-3

Lug

PO 20158

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, July 3, 2013